

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024610**Date Inspected:** 11-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Vikram Singh was present during the times noted above for observations relative to the work being performed at ZPMC.

NDT

OBG Bay 14

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08139.

Magnetic Particle Testing (MT)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG. The weld designations reviewed is as follows:

SA3168-031, 032, 033, 034

RS3481-003, 004, 005

SA3168-001, 002, 003, 004, 005, 006, 008

During random in process observations of Deck Plate DP3122 of OBG Segment 14W, this QA inspector observed

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AB/F personnel performing Magnetic Particle Testing on various welds located on Deck Panel. This QA performed Visual Testing (VT) of the Deck Panel welds and found they appeared to be in general compliance with the applicable contract documents. See Photo "A".

WELDING

OBG Bay 14

This QA Inspector randomly observed the following work in progress:

Shielded Metal Arc Welding (SMAW)

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as DP3176-001-034 located on Deck Plate to Deck Panel Diaphragm of the OBG Segment 14W. The welder is identified as 066459. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-Tc-U4b-P4. See Photo "B"

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as DP3175-001-298 located on Deck Plate to Deck Panel Diaphragm of the OBG Segment 14W. The welder is identified as 067611. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-Tc-U4b-P4.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3013R-139 located on Deck Plate of the OBG Segment 13AW. The welder is identified as 037780. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with WPS-B-P-2112-FCM-1

Flux Cored Arc Welding (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3013AU-047 located on Floor Beam to Stiffener of the OBG Segment 13AW. The welder is identified as 068445. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3020BB-028 located on Bottom Plate to SA of the OBG Segment 14W. The welder is identified as 067103. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3013AW-089 located on Floor Beam of the OBG Segment 13AW. The welder is identified as 066239. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

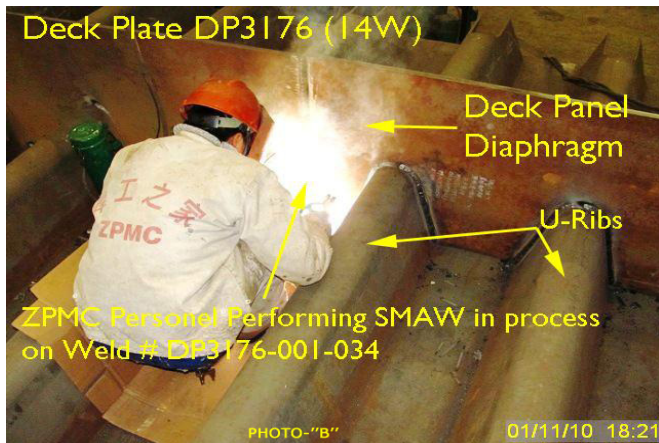
This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as

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Seg3013AW-047 located on Floor Beam of the OBG Segment 13AW. The welder is identified as 069712. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Singh, Vikram	Quality Assurance Inspector
Reviewed By:	Patterson, Rodney	QA Reviewer
